

Monday, August 25, 2014 8:04:29 AM

123794

must ship
wedn Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/25/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/27/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: cmc Date: 14-08-25 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| | | |
|-----|-------|-------|
| Run | Start | *NR1* |
| | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | |
|-----------------|---------------------|
| Draw Nbr | Revision Nbr |
|-----------------|---------------------|

D3272 Rev B

0.00

100

100

DC

Doc.Control -USB or Paperwork

Document Control
DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

0.00

110

110

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 125091
128385

3-Grind End Plate flush

DAS
38
9-89

14-8-27

Work Order ID 123794***123794***

Page 2

Monday, August 25, 2014 8:04:29 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/27/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 120 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | 1 | AUG 25 2014 | | DAS 24 9-89 |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | AUG 25 2014 | | DAS 24 9-89 |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

1 14-8-25 DMC

Work Order ID 123794

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123794

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Item ID: D350-591-312

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/27/2014 Req'd Qty: 1.00

1

* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 180 | Large Fab | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | <div>DMC 148-25</div> <div>1-Assemble Leg Assembly as per Dwg D3272.</div> <div>2-Leave one rivet out until welding is complete.</div> <div>3-Bevel Aft end for welding</div> <div>4-Inspect for foreign object as per QSI 024</div> <div>5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod B128956</div> <div>6-Grind End Plate flush</div> <div>7-Install last rivet as per Dwg.</div> | | | | | | | | |

1 2 2P 14/08/25

1 14.08.25

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/25/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/27/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

DAS
43
9-89

~~AUG 26 2014~~

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

DAS
43
9-89

AUG 26 2014

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 123794

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123794

Page 5

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/27/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|--------------------|
| 220 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *220* | <i>m 128789.</i> | | | | | <i>1</i> | <i>0</i> | <i>14-8-26</i> | <i>DAS 34 9-89</i> |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | START TIME: <i>1:00</i> | | | | | | | | |
| | OVEN TEMPERATURE: <i>320°</i> | | | | | | | | |
| | FINISH TIME: <i>1:30.</i> | | | | | | | | |
| 230 | Wing Walk as per dwg QSI005 4.4 Batch <i>M124 817</i> | 0.00 | | | | | | | |
| *230* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 240 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

AUG 26 2014

DAS
06
9-89

NIRH f all 14/08/26

Work Order ID 123794

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123794

Page 7

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/27/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 14-08-27
MLJ 14-08-27

Picklist Print

Monday, August 25, 2014 8:04:24 AM

Page 1

Work Order ID: 123794

123794

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014

Required Date: 8/27/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|-----|------|---------|-----------|---|--|-------------------|--|
| D3272-1 | | Manufactured | No | | | 110 | Each | 30.0000 | 1 | 1 | | | |
| *D3272-1* | | | | | | | | | ** | | | <i>8/14.08.25</i> | |
| Step | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------------------|---------|----------|
| WA003 <i>B123795</i> | 30 | |
| 123345 | 10 | |
| 123346 | 10 | |
| 123347 | 10 | |

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|-----|------|----------|-----------|---|--|-------------------|--|
| D3067-1 | | Manufactured | No | | | 110 | Each | 434.0000 | 1 | 1 | | | |
| *D3067-1* | | | | | | | | | ** | | | <i>8/14.08.25</i> | |
| End Plate | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| WA003 | 434 | |
| 101785 | 67 | |
| 102686 | 14 | |
| <i>117776</i> | 203 | |
| 119290 | 150 | |

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|-----|------|----------|-----------|---|--|-------------------|--|
| D3219-1 | | Manufactured | No | | | 110 | Each | 189.0000 | 2 | 2 | | | |
| *D3219-1* | | | | | | | | | ** | | | <i>8/14.08.25</i> | |
| Plate | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| WA003 | 189 | |
| 112125 | 8 | |
| 114934 | 60 | |
| <i>115339</i> | 121 | |

Picklist Print

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123794

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014

Required Date: 8/27/2014

Start Qty: 1.00

Required Qty: 1.00

D3066-1 Manufactured No 180 Each 170.0000 2 2

D3066-1

Spacer

14-8-27 DMC

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| WA003 | 170 | |
| 106302 | 7 | |
| 115867 | 52 | |
| 115868 | 52 | |
| 115869 | 40 | |
| <u>117799</u> | 19 | |

MS20600-AD4W4

Purchased

No

180 Each 2,959.000 16 16

MS20600-AD4W4

Rivets

DMC 14-8-27

| Location | Loc Qty | Loc Code |
|----------------|---------|----------|
| ST310 | 2959 | |
| 125577 | 215 | |
| <u>M128899</u> | 2744 | |

D3065-041

Manufactured

No

180 Each 14.0000 1 1

D3065-041

Step Leg Assembly

14-8-27 DMC

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| WA003 | 14 | |
| 102830 | 6 | |
| 109447 | 2 | |
| 113075 | 2 | |
| <u>115697</u> | 4 | |

D51 9410-011 x 1 B 103812

DAS
06
9-89

Picklist Print

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Page 3

Work Order ID: 123794

123794

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014

Required Date: 8/27/2014

Start Qty: 1.00

Required Qty: 1.00

D3067-1

Manufactured No

180

Each

434.0000

1

1

D3067-1

End Plate

**

114.08.25

Location

Loc Qty

Loc Code

WA003

434

101785

67

102686

14

117776

203

119290

150

AN3-35A

Purchased

No

250

Each

151.0000

2

2

AN3-35A

Bolt

DAS
38
9-89

**

DAS
28
9-89

AUG 26 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

141

m129706

41

m129934

100

D3235-1

Manufactured

No

250

Each

345.0000

2

2

D3235-1

Mounting Lug

DAS
38
9-89

**

Location

Loc Qty

Loc Code

ST519

345

102818

6

105939

17

108670

43

114441

54

116383

100

116384

55

116385

70

DAS
28
9-89

DAS
06
9-89

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 123794

123794

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014

Required Date: 8/27/2014

Start Qty: 1.00

Required Qty: 1.00

D3278-041

DAS Manufactured No

250

Each

70.0000

DAS
28
9-89

AUG 26 2014

D3278-041

DAS
38
9-89

Support Assembly

Location

Loc Qty

Loc Code

ST521

70

102349

1

109406

1

114169

39

114940

4

121431

25

NAS1149D0463J

Purchased

No

250

Each

6,378.000

DAS
28
9-89

NAS1149D0463.J

DAS
38
9-89

WASHER

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

5893

16941

8

M126221

20

M127813

6

M127904

127

M128591

44

M128995

1500

M129390

4188

Picklist Print

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Work Order ID: 123794

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

123794

D350-591-312

Start Date: 8/25/2014

Required Date: 8/27/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

250

Each

2,131.000

4 4

DAS

28

9-89

DAS

06

9-89

AUG 26 2014

NAS1149D0563J

Washer

38

9-89

**

Location

Loc Qty

Loc Code

GA

125

m125807

125

ST510a

2006

m126319

100

m128257

1906

250

Each

93.0000

2 2

**

AN5-36A

Purchased

No

AN5-36A

Bolt

DAS

38

9-89

DAS

06

9-89

Location

Loc Qty

Loc Code

ST336

93

M126105

1

M127410

7

M127460

85

250

Each

213.0000

2 2

**

D2618

Manufactured

No

D2618

Bushing

DAS

38

9-89

DAS

28

9-89

DAS

06

9-89

Location

Loc Qty

Loc Code

ST008A

213

103863

3

114872

1

123045

100

97780

109

DAS

28

9-89

Picklist Print

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Work Order ID: 123794

123794

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014

Required Date: 8/27/2014

Start Qty: 1.00

Required Qty: 1.00

D2230-3

Manufactured No

250

Each

465.0000

D2230-3

DAS
38
9-89

Mounting Lug

**

DAS
28
9-89

AUG 26 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST519

458

108668

1

109344

2

114151

1

114921

4

115583

146

116378

155

116379

149

D2856-400

Manufactured No

250

f

216.0000

D2856-400

DAS
38
9-89

Abrasion Strip 4" Wide (Per Foot)

**

DAS
28
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST426

216

117887

216

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250

Each

3,406.000

MS21042L3

Nut

DAS
38
9-89

**

DAS
28
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST307

3406

123900

948

M127410

11

M127831

41

M128401

42

M128754

2364

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Picklist Print

Page 7

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Work Order ID: 123794

123794

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014

Required Date: 8/27/2014

Start Qty: 1.00

Required Qty: 1.00

AN4-13A

Purchased

No

250

Each

696.0000

8 8

**

DAS
28
9-89

AUG 26 2014

AN4-13A

Bolt

DAS
38
9-89

Location

Loc Qty

Loc Code

CA

2

m129682

2

FG

20

122808

20

GA

14

m125709

14

ST515

660

m127432

36

m127817

22

m128739

602

8X

DAS
28
9-89

DAS
06
9-89

MS21042L5

Purchased

No

250

Each

762.0000

2 2

**

MS21042L5

Nut

DAS
38
9-89

Location

Loc Qty

Loc Code

ST307

762

125684

8

m127304

1

m127813

497

m128810

7

m129472

249

2X

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Work Order ID: 123794

123794

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/25/2014

Required Date: 8/27/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

250

Each

4,993.000

8 3 8

MS21042L4 DAS

Locknut

38
9-89

**

DAS
28
9-89

DAS
06
9-89

AUG 26 2014

Location

Loc Qty

Loc Code

ST307

4993

126275

5

m126015

12

m126275

27

m127255

63

m127376

11

m127813

891

m128300

80

m128798

1404

m129472

1000

m129934

1500

8X

NAS1149D0363J

Purchased

No

250

Each

1,959.000

4 4

NAS1149D0363J

Washer

DAS
38
9-89

**

DAS
28
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST276

5

m123441

5

ST510a

1931

m128429

1931

4X

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DART

| | | | |
|----------------------|----------------------|--|------------------------|
| DESIGN <i>QD</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>H</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED07.06.04 *H*

#123794



| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

GENERAL NOTES:

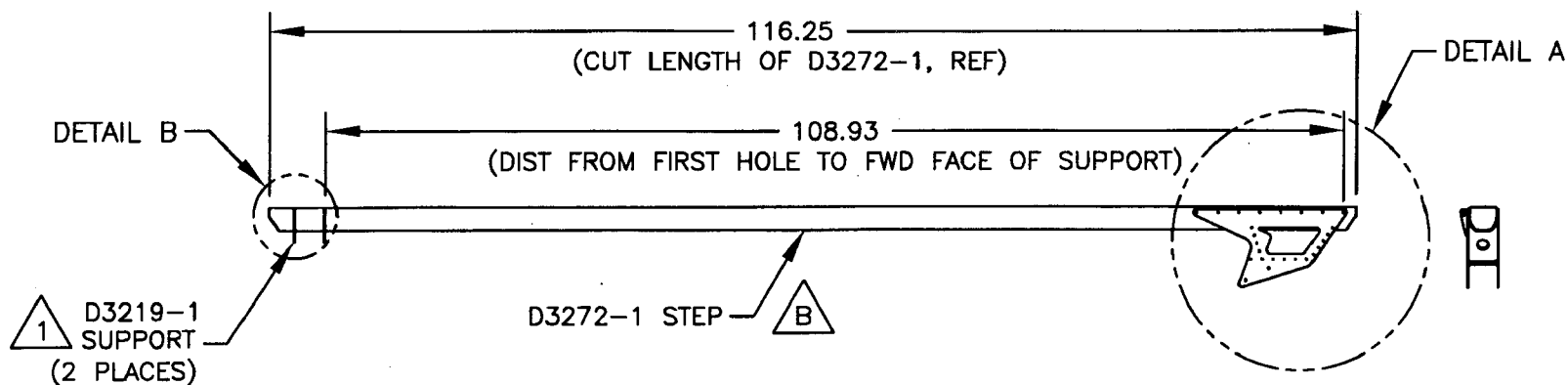
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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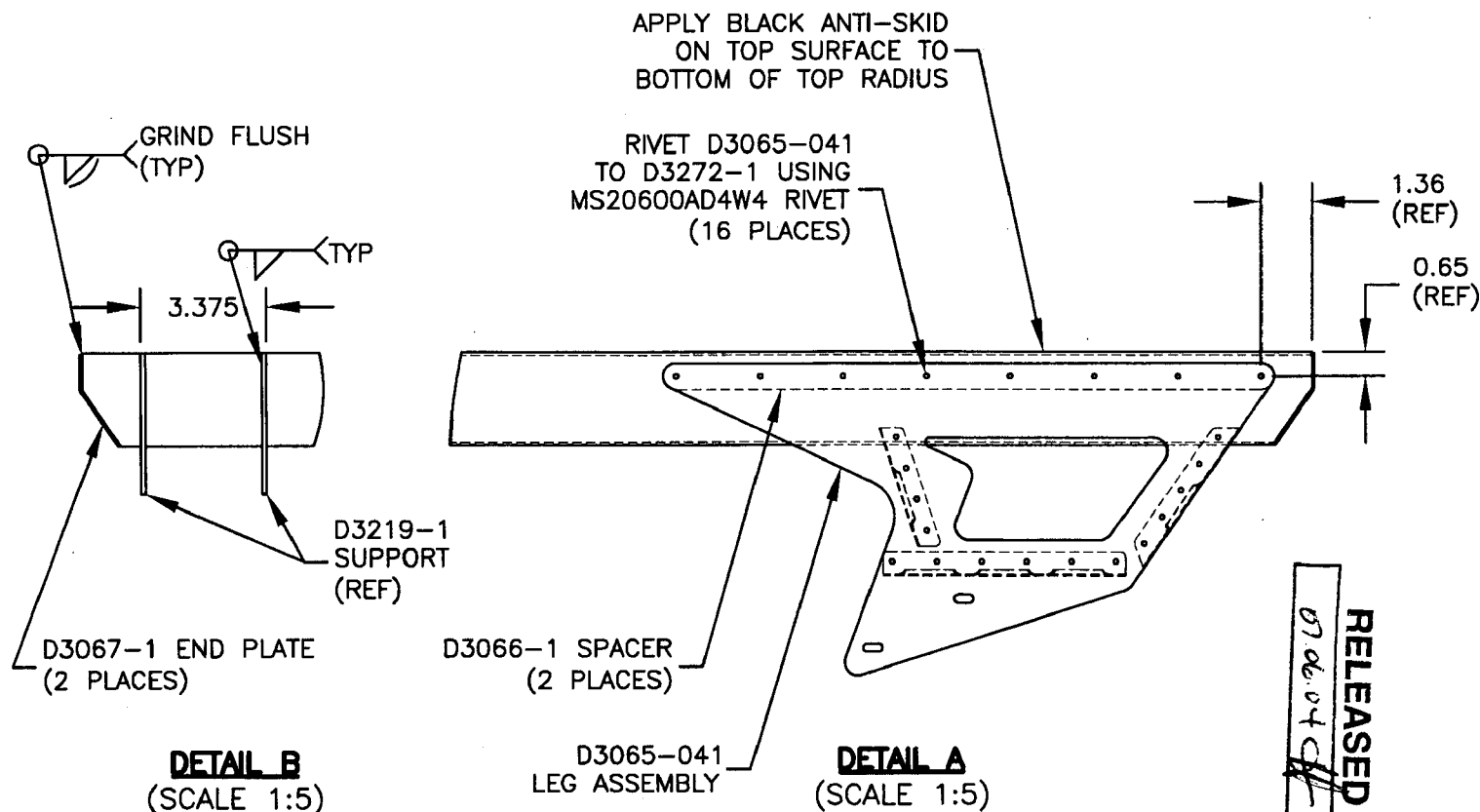
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| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. B |
| CHECKED | APPROVED | DRAWING NO. | SHEET 2 OF 3 |
| DATE | | TITLE | SCALE |
| 07.05.18 | | STEP ASSEMBLY, HI LONG | 1:20 |



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

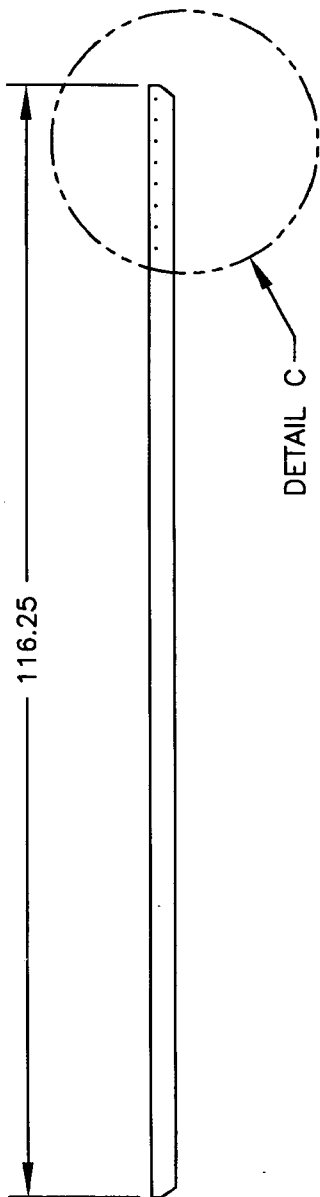




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|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>gp</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 |

RELEASED

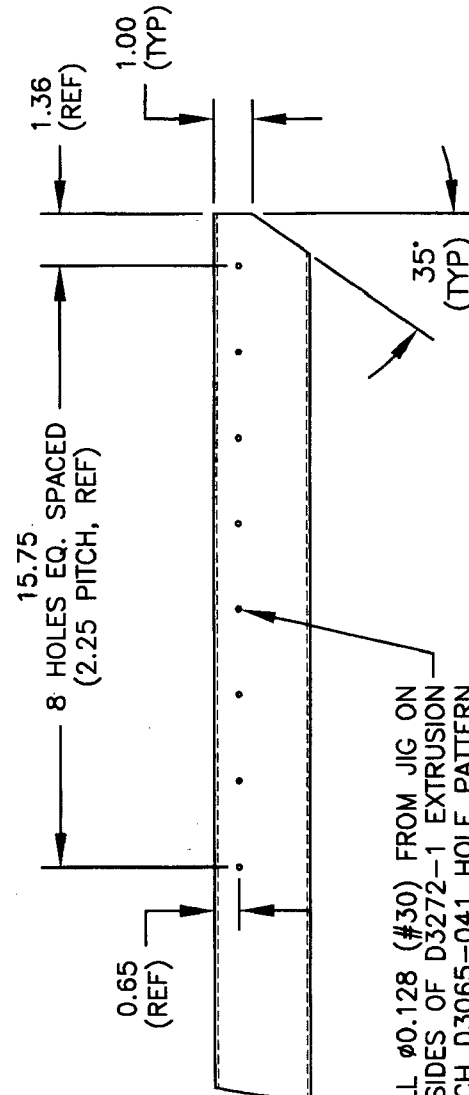
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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| Qty -211 | Qty -212 | Qty -213 | Qty -214 | Qty -215 | Qty -216 | Qty -311 | Qty -312 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|---|
| X | | | | | | | | D350-591-211 | Heli-Access-Step™ , Long Step – High Skid, LH |
| | X | | | | | | | D350-591-212 | Heli-Access-Step™ , Long Step – High Skid, RH |
| | | X | | | | | | D350-591-213 | Heli-Access-Step™ , Short Step – High Skid, LH |
| | | | X | | | | | D350-591-214 | Heli-Access-Step™ , Short Step – High Skid, RH |
| | | | | X | | | | D350-591-215 | Heli-Access-Step™ , Short Step – Low Skid, LH |
| | | | | | X | | | D350-591-216 | Heli-Access-Step™ , Short Step – Low Skid, RH |
| | | | | | | X | | D350-591-311 | Heli-Access-Step™ , Long Step – High Skid, LH |
| | | | | | | | X | D350-591-312 | Heli-Access-Step™ , Long Step – High Skid, RH |
| 1 | | | | | | | | D3070-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | 1 | | | | | | | D3070-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| | | 1 | | | | | | D3078-041 | STEP ASSEMBLY (HIGH-SHORT, LH) |
| | | | 1 | | | | | D3078-042 | STEP ASSEMBLY (HIGH-SHORT, RH) |
| | | | | 1 | | | | D3168-041 | STEP ASSEMBLY (LOW-SHORT, LH) |
| | | | | | 1 | | | D3168-042 | STEP ASSEMBLY (LOW-SHORT, RH) |
| | | | | | | 1 | | D3272-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | | | | | | | 1 | D3272-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| 4 | 4 | | | | | | | D2182B035 | RUBBER CUSHION |
| | | 2 | 2 | 2 | 2 | | | D2230-1 | MOUNTING LUG |
| | | 2 | 2 | 2 | 2 | 4 | 4 | D2230-3 | MOUNTING LUG |
| 8 | 8 | | | | | | | D2274 | RADIUS BLOCK |
| | | | | | | 2 | 2 | D2618 | BUSHING |
| 4 | 4 | 4 | 4 | 4 | 4 | | | D2732-030 | CUSHION |
| 2 | 2 | 1 | 1 | 1 | 1 | 2 | 2 | D2856-400-720 | ABRASION STRIP |
| 2 | 2 | | | | | | | D3064-1 | CLAMP |
| 1 | 1 | | | | | | | D3079-041 | SUPPORT ASSEMBLY |
| 4 | 4 | | | | | | | D3080-1 | CLAMP |
| | | | | | | 2 | 2 | D3235-1 | MOUNTING LUG |
| | | | | | | 1 | 1 | D3278-041 | SUPPORT ASSEMBLY |
| 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2 | AN3-35A | BOLT |
| 10 | 10 | 2 | 2 | 2 | 2 | | | AN4-11A | BOLT |
| | | 4 | 4 | 4 | 4 | 8 | 8 | AN4-13A | BOLT |
| | | | | | | 2 | 2 | AN5-36A | BOLT |
| 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | AN960JD10 | WASHER |
| 20 | 20 | 12 | 12 | 12 | 12 | 16 | 16 | AN960JD416 | WASHER |
| | | | | | | 4 | 4 | AN960JD516 | WASHER |
| 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2 | MS21042L3 | NUT |
| 10 | 10 | 6 | 6 | 6 | 6 | 8 | 8 | MS21042L4 | NUT |
| | | | | | | 2 | 2 | MS21042L5 | NUT |
| | | | | | | 1 | 1 | *DSI 9410-011 | STEP MODIFICATION KIT |

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.